

# Work Order ID 62446

Thursday, September 30, 2010 8:58:12 AM



Page 1

Item ID:	D2037-101	Accept		Setup	Start	
Revision ID:						
Item Name:	Arm				Stop	
Start Date:	9/30/2010	Start Qty:	10.00			
Required Date:	10/5/2010	Req'd Qty:	10.00			
Reference:						

Approvals:	Process Plan:		Date:	10-9-30	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2037	D								

100  
 NC BRAKE  
 Brake NC  
 Brake NC  
 Memo  
 Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1  
 0.00  
 0.00  
 SB 10/09/30  
 (10)

110  
 Small Fab  
 Small Fab  
 Small Fab  
 Memo  
 1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037  
 ends of D2037-101 tube as required using DT8545  
 3-Deburr as required  
 2-Flatten  
 0.00  
 0.00  
 M-L 10/10/12  
 (10X)

120  
 QC  
 Quality Control  
 QC5- Inspect part completeness to step on W/O  
 Memo  
 0.00  
 0.00  
 8/10/10/12  
 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62446**

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Item ID: D2037-101

Accept

Revision ID:

Item Name: Arm

Start Date: 9/30/2010 Start Qty: 10.00

Required Date: 10/5/2010 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: **WA025** 0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*[Signature]* 10-10-14

10/10/14 *[Signature]*

*ME*  
10-10-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 30, 2010 8:58:16 AM

Page 1

Work Order ID: 62446

Parent Item: D2037-101

Parent Item Name: Arm



Start Date: 9/30/2010

Required Date: 10/5/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-01 JLM  
IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased			No	110	f	160.1990	3.916	41.22105			
304 RD Tube .750 x .049W													

Location	Loc Qty	Loc Code
MAT	132.33549	
108498	0	
110113	0	
114482	6.6065	
114852	79.08684	
115010	46.64215	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

36  
9  
381009/30 10  
(45)

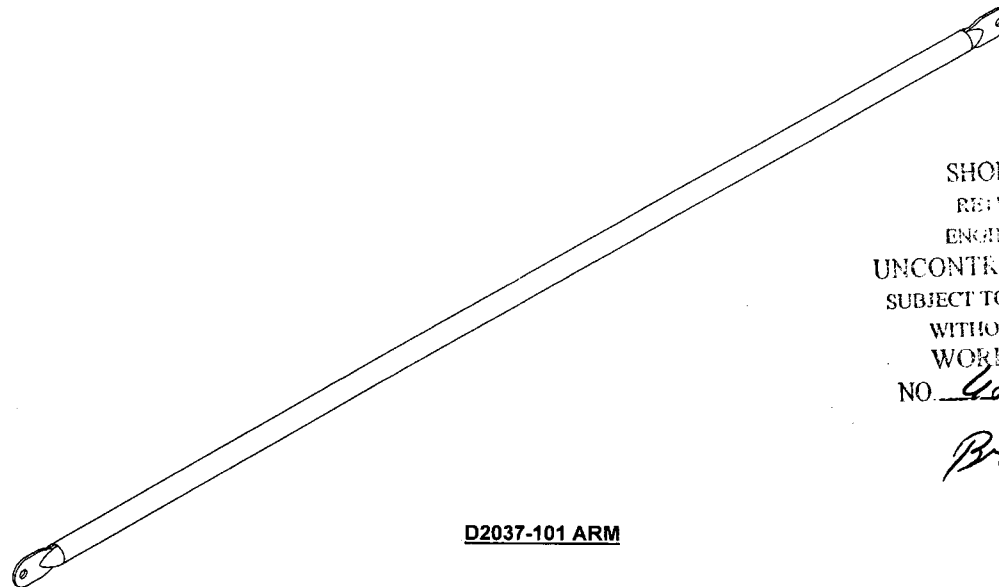
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**D2037-101 ARM**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 62414  
BS10-9-38

RELEASED  
 08.05.08

**NOTES:**

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE,  $\phi 0.750 \times 0.049$  WALL  
 REF. DART SPEC M304TR0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs
- 8) FOR FURTHER INFO SEE DRAWING D2638.

D	INCORPORATED C1, C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2037	SHEET 1 OF 2
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	ARM	NTS
DATE	08.05.08	COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
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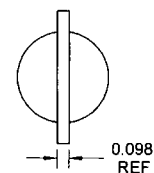
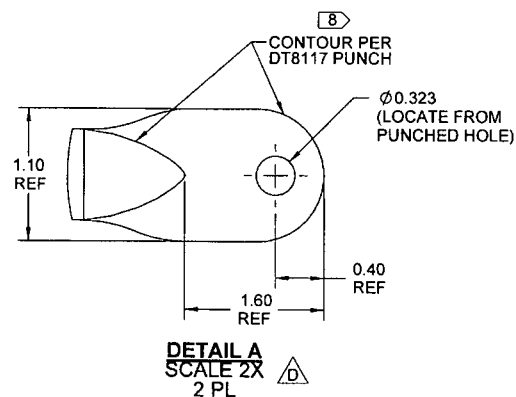
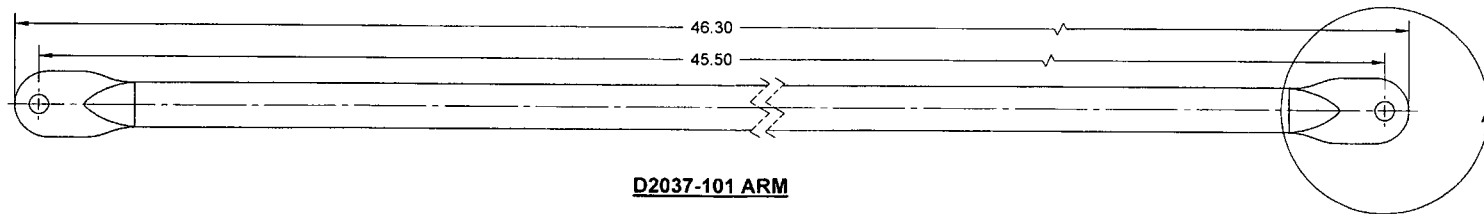
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





w/o 62446

RELEASED  
08-07-07 WAD

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DRAWN	AJS		
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MFG. APPR.		D2037	SHEET 2 OF 2
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DE APPR.		ARM	NTS
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